



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4037-1

Job Sheet 174512



Part No: D4037-1

Job Qty: 1 ea

Part Name: Aft Crossbeam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV:D AS PER
ECN 11-554 11-05-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/9/18	4/9/18	0.00	0.00	Start Up Waterjet		OK 18/03/27
100	Waterjet	1 pcs	4/9/18	4/9/18	0.00	0.89	Waterjet1		OK 18/03/27
110	CNC Vertical Machining	1 pcs	4/9/18	4/9/18	0.00	3.70	HAAS1-4		K+ 18-04-27
120	QC	1 pcs	4/9/18	4/9/18	0.00	0.00	QC2 Machining-2		K+ 18-04-27
130	QC	1 pcs	4/9/18	4/9/18	0.00	0.00	QC8 Machining-2		OK 18/04/28
140	HandFinish	1 pcs	4/9/18	4/9/18	0.00	0.19	HandFinish1		SA 18-04-30
150	Powdercoat	1 pcs	4/9/18	4/9/18	0.00	0.20	Powdercoat1		SA 18-04-30
160	QC	1 pcs	4/9/18	4/9/18	0.00	0.00	QC3		11 APR 30 2018
170	Packaging	1 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-2		DO 18-05-02
180	QC21-SA	1 Ea	4/9/18	4/9/18	0.00	0.00	QC21		21 MAY 02 2018

Part Op 100 - Cut blank as per file D4037-1_BLANK

Descriptions: 110 - MACHINE AS PER FOLI FA877 AND DWG

M138760 START: 11:40 O.V.T. 320° FINISH: 12:10.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X16.000	6061-T6 Bar 1.00 X 16.00	3.9000 ft (3.9 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X16.000	4	24	0

Part Specifications

Specifications could not be found.

Plex 3/16/18 2:19 PM Dart.Gagnon.Michelle



Container No: S055614



Part: D4037-1

Job No: 174512

Serial No/Batch: S055614

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/27/18

SAGE

PF

100-100-100-100-100

DART AEROSPACE LTD		Work Order: 174512
Description: Aft Crossbeam		Part Number: D4037-1
Inspection Dwg: D4037	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.530	+/-0.010	0.523	✓		Kt-05	vern.
0.25	+/-0.030	0.260	✓		65011351	micronetre.
2.00	+/-0.030	2.004	✓		Kt-05	vern.
2.75	+/-0.030	2.753	✓		Kt-05	vern.
1.00	+/-0.030	1.012	✓		" "	" "
R0.032	+/-0.010	0.032	✓		—	R-G
42.87	+/-0.030	42.87	✓		—	TAPE
1.38	+/-0.030	1.375	✓		Kt-05	vern.
1.750	+/-0.010	1.750	✓		" "	" "
2.125	+/-0.010	2.125	✓		" "	" "
2.250	+/-0.010	2.250	✓		" "	" "
0.875	+/-0.010	0.875	✓		" "	" "
0.875	+/-0.010	0.875	✓		" "	" "
6.000	+/-0.010	6.000	✓		" "	" "
1.125	+/-0.010	1.125	✓		" "	" "
0.86	+/-0.030	0.858	✓		" "	" "
1.38	+/-0.030	1.378	✓		" "	" "
8.04	+/-0.030	8.04	✓		" "	" "
5.29	+/-0.030	5.29	✓		" "	" "
Ø0.316	+0.006/-0.001	0.316	✓		" "	" "
Ø0.391	+0.006/-0.001	0.391	✓		" "	" "
0.38	+/-0.030	0.380	✓		" "	" "
7.75	+/-0.030	7.75	✓		" "	" "
R0.63	+/-0.030	0.63	✓		—	R-G
R1.00	+/-0.030	1.00	✓		—	" "

DAS

Measured by: 1 Kt	Checked by: MK	QC Inspector:
Date: 9-89 2018-04-27	Date: 18/04/29	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.06.21	Dwg Rev updated	KJ	
C	17.07.13	Dimensions updated per Dwg Rev E	KJ	